

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-018841**Date Inspected:** 13-Nov-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Wang Jie**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance(QA) Inspector Mr.Shrikant Utekar was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. The QA Inspector observed and/or found the following:

BAY # 14

ULTRASONIC TESTING

ZPMC NWIT: 07335

This QA Inspector performed Ultrasonic Testing (UT) of approximately 10% of the length previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an (UT) report on this date. The members are identified as SEG3020AP. The weld designations are as follows:

SEG3020AP-003, 004, 005

MAGNETIC PARTICLE TESTING

ZPMC NWIT: 07342

This QA Inspector performed Magnetic Particle Testing (MT) of approximately 15% of the length previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an (MT) report on this

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

date. The members are identified as SEG3020AP. The weld designations are as follows:

SEG3020AP-003, 004, 005

This QA Inspector randomly observed the following work in progress.

BAY # 14

OBG13 EAST

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 049861 performing the Shielded Metal Arc Welding process on weld 116 located at PCMK SEG3007. ZPMC QC Mr. Zhong Yong Gang was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-P-2212-Fcm-1.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 200113 performing the Shielded Metal Arc Welding process on weld 117 located at PCMK SEG3007. ZPMC QC Mr. Zhong Yong Gang was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-P-2214-Fcm-1.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 208035 performing the Flux Cored Arc Welding process on weld 120 located at PCMK SEG3007B. ZPMC QC Mr. Zhong Yong Gang was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-T-2132.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 037705 performing the Flux Cored Arc Welding process on weld 033 located at PCMK SEG3007F. ZPMC QC Mr. Zhong Yong Gang was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-T-2233-Tc-u4b-f.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 068494 performing the Flux Cored Arc Welding process on weld 019 located at PCMK SEG3007G. ZPMC QC Mr. Zhong Yong Gang was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-T-2233-Tc-u4b-f.

This Quality Assurance (QA) Inspector observed ZPMC personnel performing heat straightening, member identified as FB3124. Distortion appeared to be caused by welding. ZPMC Quality Control (QC) inspector identified as Mr. Wang Xu was present to monitor the heat straightening process. Weld number identified as SEG3007J-032. The heat straightening appeared to comply with heat straightening Report HSR1 (B)-9836.

OBG 14 WEST

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 045175 performing the Flux Cored Arc Welding process on weld 013 located at PCMK SEG3020AZ. ABF QA Mr. Shen was monitoring this welding operation. The welding variables recorded by QA appeared to comply with WPS-B-T-2231-U2-F.

OBG 14 EAST

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

This Quality Assurance (QA) Inspector observed ZPMC personnel performing Ultrasonic testing for the splice weld between AP3005 and AP3006. Weld number identified as SEG3019AP-005.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

No significant conversations were reported on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, +(86) 1500 042 2372, who represents the Office of Structural Materials for your project.

Inspected By:	Utekar,Shrikant	Quality Assurance Inspector
Reviewed By:	Patterson,Rodney	QA Reviewer
